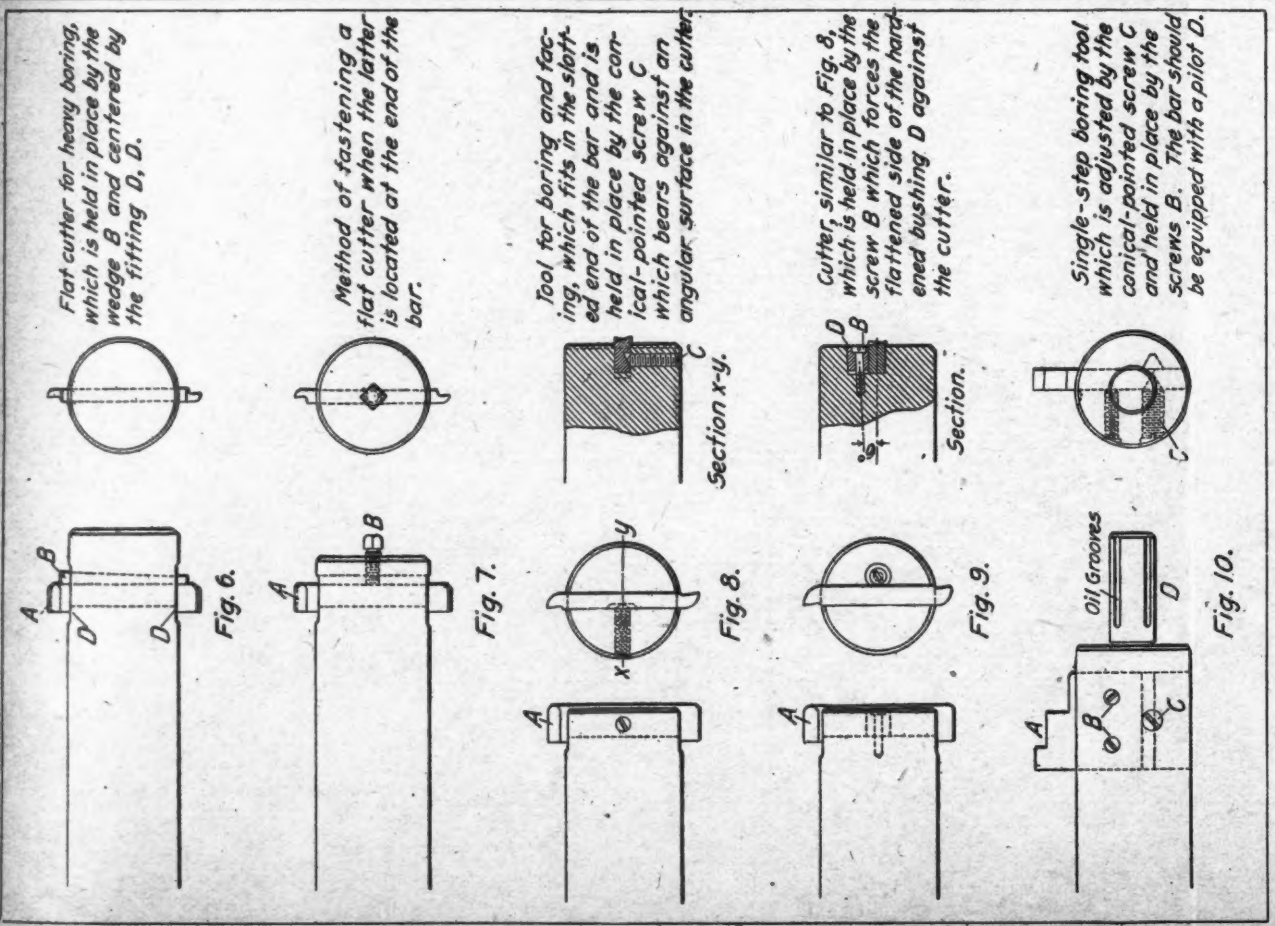


7. Finish the face by grinding on the left-hand side, being careful to leave sufficient stock for finishing the inner face of the flange.

traverse of the platen to $\frac{1}{2}$ inch per revolution of the work, and take the finishing cuts allowing the wheel to pass through the hole several times without feeding it.

the flange is finished to the required finish, by making a traverse of the platen to $\frac{1}{2}$ inch per revolution of the work, in the same manner, remove the finished work, and place another bearing on the mandrel.

II.—BORING BARS AND HEADS



III.—BORING BARS AND HEADS

Boring bar for light work, having two cutters A which are held in place by flattened bushings D and angular screws B as in Fig. 9.



Fig. 11.

Another type of bar for light work, having two cutters A which are held by flattened bushings D and angular screws B inserted in the end of the bar.



Fig. 12.

Cutters for boring and facing, which are adjusted by the conical-pointed screw C and held in place by bolts B, the heads of which enter the grooves D.

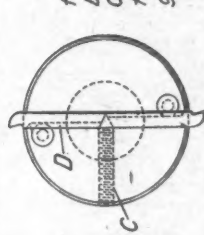


Fig. 13.

Boring head for finishing cuts, having six tools which fit in tapering slots thus permitting adjustment. The cutters are held by the screws B and clamp D.



Fig. 14.

Roughing tool for cast iron. The four cutters fit tightly in their slots and are held by the screws B.

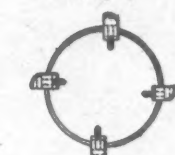


Fig. 15.

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IV.—BORING BARS AND HEADS

Bar for cast iron with two cutters A which are held by screws B and are adjusted by the hardened screws C, the heads of which fit in slots in the cutters.

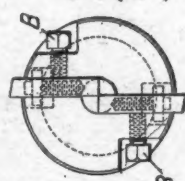


Fig. 16.

Boring head for steel, with high-speed steel cutters which are clamped by the screws B and adjusted by the screws C in the ring D.

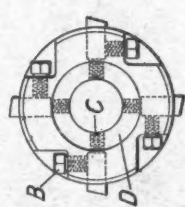


Fig. 17.

Bar for brass and other light work, having two cutters A which are adjusted by changing their position in the tapering slots, and clamped in place by driving in the taper pins B.

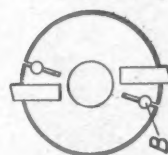


Fig. 18.

Boring head for finishing, having six blades which are clamped by screwing in the taper-headed screws B.

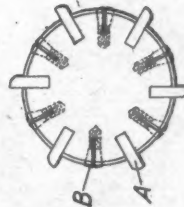


Fig. 19.

Design of head adapted to small work. The cutters A fit in slots in the ring B and are adjusted by screwing the ring C inward after the ring D is loosened.

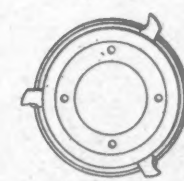


Fig. 20.

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